

Work Order ID 145186***145186***

Wednesday, May 04, 2016 9:25:40 AM

Accept

N900040100Setup Start ***NS1***Stop ***NS2***

Item ID: D3270-041

Revision ID:

Item Name: Fuel Scupper Assembly

Start Date: 5/5/2016 Start Qty: 2.00

Required Date: 5/17/2016 Req'd Qty: 2.00

2

Cust Item ID:

Customer:

2

Reference:

Run Start ***NR1***Stop ***NR2***Approvals: Process Plan: 2m Date: 16/05/04 Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3270	Rev B								
100	Small Fab	0.00							
100									
Small Fab	Memo	0.00							
Small Fab	Cut D3270-3 as per Dwg D3270								
110	Weld per dwg A/R Aluminum rod Batch: <u>101399</u>	0.00							
110									
Large Fab	Large Fab	0.48							
Large Fab	Memo								
	Weld D3270-3 to D3270-1 as per Dwg D3270 using welding Jig D3270-041T1 and QSI 004.								
120	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
120									
QC	Memo	0.00							
Quality Control									

MAY 05 2016

2 EL 17-2712 FEB 22 2017 lpc

DQA: _____ Date: _____



QA Closed: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

Work Order update only ☐

Work Order: _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS					
Part No. _____		Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐		
NCR No. _____		Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐		
		Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐		
Date: _____	Step #: _____	QTY Effective: _____					

MRB (QSI042) Approval

Description Work Order Deviation 	Disposition 	Completed By
		Lead hand / Supervisor Approval Verification
		QC / QA Coordinator Approval

Root Cause			FAULT CATEGORY		
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐	OTHER: _____			
Misidentified ☐	Past Due ☐				

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Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC5- Inspect part completeness to step on W/O	0.00							
130						2			DAS 38 9-08
QC	Memo	0.04							
Quality Control									FEB 23 2017
140	Chemical Conversion Coat per QSI005 4.1	0.00							
140									
HandFinish	Memo	0.00							
Hand Finishing									2017/02/23 BEB.
150	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
150									
Powdercoat	Memo	0.08							
Powder Coating	START Time: 10:10 OVEN TEMPERATURE: 320° FINISH TIME: 10:40					2	17-02-28		348

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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160	QC3- Inspect Part Finish	0.00							DAS 38 9-89
160						2			
QC	Memo	0.02							
Quality Control									FEB 28 2017
165	Identify as per dwg & Stock Location: <u>51024</u>	0.00							
165						2			
Packaging	Memo	0.02							DAS 6 9-89
Packaging									MAR 01 2017
170	QC21- Final Inspection - Work Order Release	0.00							DAS 21 9-89
170									MAR 02 2017
QC	Memo	0.20							
Quality Control									DAS 21 9-89 MAR 02 2017

DQA: _____ Date: _____

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Picklist Print

Wednesday, May 04, 2016 9:26:00 AM

Page 1

Work Order ID: 145186

145186

Parent Item: D3270-041

D3270-041

Parent Item Name: Fuel Scupper Assembly

Start Date: 5/5/2016

Required Date: 5/17/2016

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A New Issue 05-11-01 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3270-1		Manufactured	No			100	Each	35.0000	1	2			

D3270-1

Mounting Base

EL 11-276

Location

Loc Qty

Loc Code

WA002

35

130540

35

2

M6061T6T0.375W.035

Purchased

No

100

f

73.5023

0.6666

1.403368

MAY 05 2016

FF

M6061T6T0 375W 035

6061-T6 RD Tube .375 x.035W

Location

Loc Qty

Loc Code

MAT013

73.502258

124491

64.5

m130071

9.002258

1.403368

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



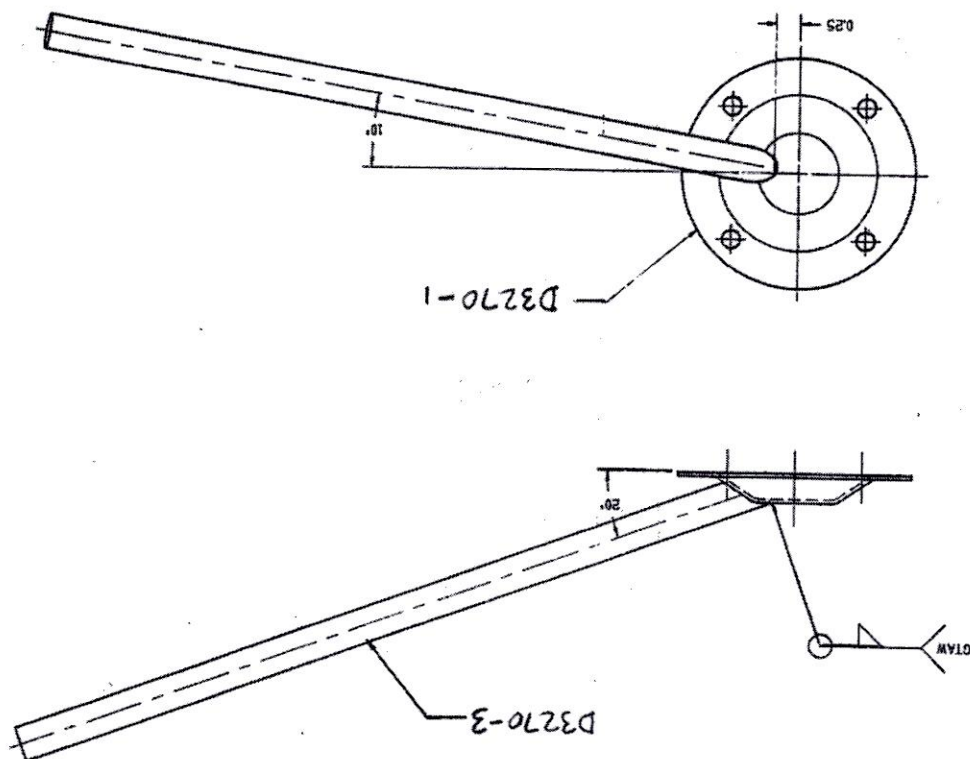
QA Closed: _____ Date: _____

Work Order update only ☐

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Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐								
		OTHER :							

- NOTES:
- 1) WELD PER DART BSI 004 USING 5356 FILLER ROD.
 - 2) FINISH: CHEMICAL CONVERSION COAT PER BSI 005 4.1
 POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER BSI 005 4.3
 - 3) ALL DIMENSIONS ARE IN INCHES
 - 4) TOLERANCES ARE PER DART BSI 018 UNLESS OTHERWISE NOTED.
 - 5) CONTOUR MAY BE ALTERED TO DOWNED SHAPE AT FABRICATOR'S DISCRETION

D3270-041 FUEL SCUPPER ASSEMBLY



RELEASED 04.02.23

DESIGN		DRAWN BY		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. B	SHEET 1 OF 2	DATE	05.07.14	TITLE	FUEL SCUPPER DRAIN ASSEMBLY NTS	SCALE
CHECKED		APPROVED		DRAWING NO.	D3270						
											</



for information

info 145186

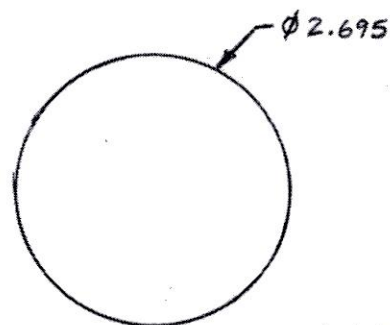
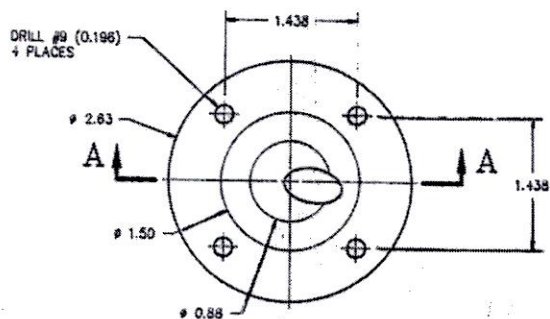


DESIGN	<i>HA</i>	DRAWN BY	<i>HA</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>CP</i>	APPROVED	<i>HA</i>	DRAWING NO. D3270
DATE	05.07.14	TITLE	FUEL SCUPPER ASSEMBLY	REV. B SHEET 2 OF 2
A	04.02.20	NEW ISSUE		SCALE MTS
B	04.02.20 05.07.14	ADD D3270-1 FLAT PATTERN		

RELEASED
04.02.23



SECTION A-A

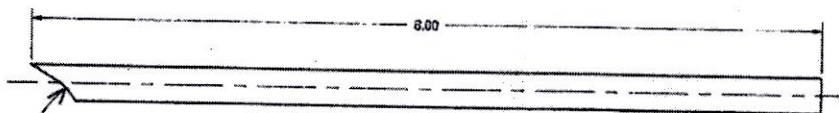


D3270-1 FLAT PATTERN

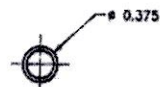


D3270-1 MOUNTING BASE

MATERIAL: 6061-T6 ALUMINUM SHEET 0.040" THICK PER QQ-A-250/11 (M6061T6S.040)



CONTOUR TO FIT
D3270-1



D3270-3 FUEL OUTLET TUBE

MATERIAL: 6061-T6 ALUMINUM TUBING 0.375" OD X 0.035" WALL (SEAMLESS)
PER MW-T-700/6 OR QQ-A-200/8 OR QQ-A-225/8
(M6061T6T0.375W.035)

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